•											
Work Orde Tuesday, July 31					Page 1						
Item ID: Revision ID: Item Name:	D350-604-04 Rear Locker E			Accept	*N900	<b>04</b> 0	100	<b>)</b> * :	Setup Star	IVI	S1* S2*
Start Date: Required Date: Reference:	7/31/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:					IN	<b>5</b> /
Approvals:	Process Pla	10		Tooling: SPC (Y/N):	Date:			I	Run Star Sto	" <b>[\]</b>	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D2273 D350-604-041	F B										
*1 \\ \n \\ \text{DC} \\ Document Control	·	CHG003	DL bluefile and create labels per for D2273 rev.E (new gelect for D2273 rev.F (new prime	oat)	16 2/06/13		·		MCJ	_177	(08)
110		DUD CHACD'C		0.00					2		

\*110\*

PURCHASING

0.00

Purchasing

Purchasing

Description: D350-604-041 Rear locker extender. Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 122 335 4 x 2600-LW Retaining washers - Ship to Delastek B 12/624

										DQA:	Date:	
NCR:	Yes / No	)			WORK ORDER NON-	100	NFORM	ANCE / UPDAT	Έ	•		. 7. 1. 7.
								·		QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PROCESS .	/	
Part N	No				Scrap Machining Small F Use-as-is Thermoforming Finishi			rosstube mall Fab Finishing mposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update	T	Initial	Action		Sign &		
Cause	Date	Step	Qty	ŀ	or Non-conformance	1	nief Eng	Description	on	Date	Verification	QC Inspector
Doc/Data					1							
Equip/Tooling		Ì										
Operator						İ						
Material												
Setup												
Other												
Process												
Supplier						1.						
Training												
Unapproved												
					F	AUI	LT CATE	GORY				
Landi	ng Gear			_	General	_	_			_		•
	Bendir	g			Bend	L	Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/Uncle	ar	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maintenance				Part Moved		
	Heat T	reat			Countersink	Mislabeled				Positioned Wrong		_
	Inspection Strip in Tube Cut Too Short				Cut Too Short						Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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# \*88726\*

Page 2

Item ID: Revision ID:	D350-604-04	41		Accept	*N900	04010	<b>)</b> ()*	Set	up Start	*NS1*
Item Name:	Rear Locker E	extender							Stop	*NS2*
Start Date:	7/31/2012	Start Qty: 1.00	*1*		Cust Item I	D:				
Required Date:	8/24/2012	Req'd Qty: 1.00	*1*		<b>Customer:</b>					
Reference:			•							
Approvals:	Process Pla	in:	Date:	Tooling:	D:	ate:		Rur		*NR1*
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			Stop	*NR2*
Sequence ID/ Work Center II	<u> </u>	Operation Description		Set Up/ 🐁 Run Hours	Tool ID	Tool # Pla Coo				Reject Insp. Number Stamp
120		Receive & Inspect for D	amage & Mat'l Certs	0.00						
*120*		Packaging							lus	[Mis (1)
Packaging		Memo		0.00			-		1	
Packaging		Ensure a coattached.	py of Certification of Confo	rmity and process sheet t	from Delastek is					D1
										410,0
130		QC5- Inspect part comp	leteness to step on W/O	0.00						•
*130*				(DA	511					
QC		Memo		0.00	\$ 17/08/13					****
Quality Control	•	Check hole	locations to template. DT 8	824 Check process sheet	and audit.					
	-									
									*	
140			* *	0.00						
*140* Small Fab		ا مانيني	•	0.00						7
Small Fab		Memo INSTALL I	DECALS AS PER DWG	0.00 , -	•					

NCR:	Yes	/	No

## WORK ORDER NON-CONFORMANCE / UPDATE

Dans the Date: 12 00/14	ř	
N.		

										QA Closed:	Date:	MASIH.		
Work Order:	9 9	172	6		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No.		<b>3</b> 33	0-60	<u>4-04</u> ]	Rework Scrap Use-as-is Work Order Update	]	Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Supplier Supplier				Engineering Quality Other			
Root				Descri	ption of work order update	Ini	tial	Act	ion	Sign &				
Cause	Date	Step	Qty	(	or Non-conformance	Chie	f Eng	Descr	iption	Date	Verification	QC Inspector		
Doc/Data  Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	19/04/0	# 140	X	Found Perin See a B.(. S	Small (Radis ea + P.n L. le Haele Pic.	Colos 17/0s	<b>42</b>	Soulf Acea Crack be. Le Prine as as 2007 Le attack En	per	A 13. 8-13	rolochi3	0AS) 16 057042 12/05/10		
					F	AULT	CATE	GORY						
Landing	Gear				General					_				
	Bending Centre No Cracks	ot Conce	ntric to	o/s	Bend BOM/Route Broken/Damaged	Н	rain ardwa		·	Ovalized Over/Under	<del> </del>	Pressure/Forced Temperature/Cure		
	Crushed/	^rimnad		<u> </u>	Burrs		-	on Incomplete ions Incomplete/L	Inclose	Part Incorre Part Lost/M		Weld Wrong Stock Pulled		
-	Cuffs	cimpeu.	-	-	Contamination	$\vdash$		nance	Ticlear	Part Moved	12211 B	I wrong stock Pulled		
	Heat Trea	t			Countersink	$\boldsymbol{\vdash}$	islabe		-	Positioned V				
	Inspection		Tube		Cut Too Short	$\mathbf{H}$	lisread	.,	<b> </b>	Power Loss/		Other		
	Ripples in	•			Drill Holes	$\mathbf{H}$	ffset		<b>L</b>	CRACK in		11		
	Torque W	aves in E	xtrusio	n	Drawing	По	ut of C	Calibration		GUTAN EN	1,000			
Turning Sequence Finish					Out of Sequence									
Wave/Twist in Tube Folio				Outside Dimensions										

Work Order ID 8872	Wo	rk	Orde	rID	88726
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\*88726\*

Page 3

Twesday, July 3	1, 2012 3:02	2:17 PM		<u> </u>	//0							r uge 3
Item ID: Revision ID: Item Name:	D350-604-0			Accept	)*	Setup	Start Stop	ıv.	S1* S2*			
Start Date: Required Date: Reference:	7/31/2012 8/24/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	Cust Item ID: Customer:						
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ate:		]	Run	Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center II 150 *150* QC Quality Control	D	Operation Description QC5- Inspect part comple		Set Up/ Run Hours 0.00 DAS 16 0.00 \$289	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*160 *160* Packaging Packaging		Packaging  Memo  Identify and the Location: PPP Rev:		0.00 0.00 er PPP D350-604-041							0	3/050
170 *170* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00						いび	12	12/08
												12/08

								•			DQA:	Date:	,
NCR:	Yes	/ No				WORK ORDER NON-C	10:	NFORI	MANCE / UPI	DATE			a.
									• •		QA Closed:	Date:	
Work Ord	۰					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Work Ora	er.					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	۷n					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
,						Use-as-is		l	noforming	Finishing	}	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite	1	Supplier	1
									·	-			-
Root					i .	ption of work order update	1	Initial	E .	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data	_								·				
Equip/Tooling													
Operator	L												
Material			1	İ									·
Setup													
Otḥer				ļ									
Process													
Supplier							İ						
Training				ŀ	İ		1						
Unapproved									<u> </u>				
		•				F	AUL	T CATE	GORY				
Landi	ng (	Gear				General		-	•	_	_	<u></u>	<b>-</b>
		Bending				Bend		Grain		<u>.</u>	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire	<u></u>	Over/Under	r tolerance	Temperature/Cure
	L	Cracks			<u> </u>	Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ect	Weld
	_	Crushed/	Crimped.			Burrs	Instructions Incomplete/Unclear				Part Lost/M	lissing	Wrong Stock Pulled
		Cuffs			<u></u>	Contamination	L	Mainte	enance		Part Moved		
		Heat Treat Countersink				Countersink		Mislabe	eled		Positioned	Wrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Tuesday, July 31, 2012 3:02:21 PM

Work Order ID: 88726

\*88726\*

Parent Item:

D350-604-041

Parent Item Name: Rear Locker Extender

\*D350-604-041\*

**Start Date:** 7/31/2012

Required Date: 8/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:Q03.12.01ReformatKJ/RF

12.02.07 AS PER ECN12-521 DD verf:JLM

IPP REV:R

IPP REV:S 12.04.04

AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item		Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2269		Manufactured	No				Each	36.0000		1		$\cap$	
*D2269*									**		d d	/	
				<b>Location</b>		Loc	Qty	Loc Code					
				ST007			32				_		
					80011		20				<del></del>		
					86944		12		_		<del>_</del>		
				ST009			4				_		
					78920		4		· _		_	•	• •
2600-6		Purchased	No			110	Each	391.0000	4	4 )			
*2600-6*									**	2/8/13	3	11	
Camlock Stud										•			

Location	Loc Qty	Loc Code	
ST380	391		
120077	8		
121556	4		
122317	34		
122335	145		<u> </u>
122441	200		

NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	ANCE / UP	DATE		•			
											(	QA Closed:	Da	ate:	•
Work Ord	er.					DISPOSITION				AGAINST D	DEP	ARTMENT,	PROCESS		
Part I	No.		•			Rework Scrap Use-as-is		Therm	Skid-tube Machining Moforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor re/Packaging		Engineering Quality Other
NCR I	NO.					Work Order Update	ا ز		Large Fab	Composite			Supplie		
Root					Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause	,	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desci	ription	┙	Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														,	
			•		_	F	AUL	LT CATE	GORY	•					•
Landi	nding Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread				Ovalized Over/Under Part Incorrec Part Lost/Mi Part Moved Positioned V	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
1		Rinnles in	Rend			Drill Holes		Offset		L		•	-	L	

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Pickiist Print Tuesday, July 31, 2012-3:02:21	1 PM							Page
Work Order ID: 88726		*88	3726*					
Parent Item: D350-604-041			350-604-0					
Parent Item Name: Rear Locke	r Extender	1,	.5:50-6004-0	14 1		Start Date:	7/31/2012	Required Date: 8/24/2012
						Start Qty:		Required Qty: 1.00
								Required Qty. 1.00
2600-LW	Purchased	No		110	Each	515.0000 4	4[/	
*2600-1 W* Camloc Retaining Washer						**	_ <del>V</del> _	
			<b>Location</b>	Loc Ot	Y	Loc Code		
			380	20	00			_
			122452	20			-	-
			ST380	3				_
			121524 122317		12		¥	_
				20	00			-
			ST381 121287		l 1		*****	-
			ST398		2			-
			120648		2			-
D350-604-041P	Purchased	No		110	Each	3.0000 1	1	
*D350-604-04						**	B8872	do
			<b>Location</b>	Loc Ot	Y	Loc Code		
	•		CA		3			_
			87193		1		emma.	-
			87194		1			-
	3.6	X.T	87196	140	I Foot	41,0000		_
D2268	Manufactured	No		140	Each	41.0000 1	1 ()	1/
)*D2268*	••					**	_ <b>S</b> Y_	12/8/13
Decal			•				•	
	, · · ·		<b>Location</b>	Loc Qt	Y	Loc Code		
	4 - 4		ST007		20			-
			80010		20			-
•			ST009		21			<u>.</u> .
			69592 <u>7</u> 8908		2 7		. [	_
			86752		12		<del> </del>	-
								-

Shop Packet Print

Page 2

Tuesday, July 31, 2012 3:02:21 PM

	11	,	
NCR:	Yes	/	No

Date:

NCR: Y	es / No				WORK ORDER NON-	CONF	UKIV	MANCE / UPDATE	QA Closed:	Date:		
Work Orde	ar.				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Work Order:					Rework Scrap Use-as-is		٨	Skid-tube Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR No.					Work Order Update	]		Large Fab Composite	Supplier			
Root				Descr	iption of work order update	Init	ial	Action	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Description	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator							İ					
Material								·				
Setup	_					-						
Other	_											
Process												
Supplier 												
Training Unapproved				:								
Onapproved		.1	<u> </u>			FAULT (	CATE	GORY				
Landi	ng Gear				General	· · · · · · · · · · · · · · · · · · ·						
	Bending			Γ	Bend	G	rain		Ovalized		Pressure/Forced	
	Centre Not Concentric to O/S Cracks			o/s	BOM/Route Broken/Damaged		Hardware Inspection Incomplete		Over/Under tolerance Part Incorrect		Temperature/Cure	
											Weld	
	Crushed/Crimped.				Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled	
	Cuffs				Contamination		Maintenance		Part Moved			
	Heat Treat				Countersink		Mislabeled		Positioned Wrong			
	Inspection Strip in Tube				Cut Too Short		isread	· [	Power Loss/Surge Other			
	Ripples in Bend			Drill Holes		ffset	<b>1</b>					
	Torque '	Waves in	Extrusio	n [	Drawing	O	Out of Calibration					
	Turning	Sequence	!		Finish	O	ut of S	Sequence				
	Wave/Twist in Tube				Folio	O	utside	Dimensions				

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#### **Solve Composites**

29 Distribution Way Suite 101 Plattsburgh, NY 12901

Phone: 518-324-3838 Fax: 518324-5530

### Packing List

**Bill** Dart Aerospace

To: 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Canada

<u>em</u> 1 Ship Dart Aerospace

**To:** 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Canada

Shipment No: 13421

Shipment Date: 08/09/12

Ship Via: Fedex Freight

Order Number: 11941

Order Date: 07/31/12

Customer Code: DART

Phone: (613) 632-9577

**PO Number: 17583** 

Terms: Net 30 Days

 	Quan	ntity				Job	
<u>Open</u>	Shipped	Back Ord	<u>Canceled</u>	<u>Unit</u>	Description	Revision	Number
6	2 <b>1</b>	4		EA .	D350-604-041P D350-604-041P Rear Locker Extender	F	11941-01

Packing Clerk's Initials Solve Composites

W.F

Received In Good Order By Dart Aerospace



#### **Certificate of Conformance**

**Solve Composites** 

29 Distribution Way

Plattsburgh, New York, 12901

**USA** 

Dart Aerospace Order Number: 17583

Part Number: D2273

Quantity: 1

Drawing Number: D2273, DT8020

Serial Number (s): 0010

Date: August 9, 2012

W8

Non-Conformances: None

This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.

Jerry Reyell

**Project Manager** 

**Solve Composites** 

#### **Eric Downing**

From:

Isam El-Kassis <ielkassis@dartaero.com>

Sent:

Friday, August 10, 2012 1:19 PM

To:

**Eric Downing** 

Cc:

Alisa Langille; Jerry Reyell; <psmith@dartaero.com>; L Lacelle

Subject:

Re: D350 rear locker again

Agree

Sent from my iPhone Isam El-Kassis

On 2012-08-10, at 13:12, "Eric Downing" < edowning@dartaero.com > wrote:

Hey guys me again

When I was inspecting the latest two rear lockers that just came in I found one with a small pin hole in the primer that has a crack in it. To me it appeasers to have been caused by a bubble in the primer. You can see it in the attached pictures on this email. It's not a huge issue but it does prevent us from relesing the part.

Isam I don't believe that this deserves to be returned due to the fact that we can do a minor touch up to the primer here. It only requires some minor buffing to remove the primer in that location and re priming the complete rear locker to have the color match. This can be scheduled in this weekend and would be ready to be put into a box on Monday afternoon. But it's something that we would like to avoid in the future. Please let me know that this is acceptable.

**Thanks** 

Eric Downing
QC Corrdinator
Dart Aerospace LTD

<IMG 0530.JPG>

<IMG 0529.JPG>